

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008680**Date Inspected:** 26-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (1AW)

FCAW Process:

Welding of weld joint -003 located on PCMK SSD34-PP8.5. Welder is identified as 220063

ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U5-F.

FCAW Process:

Welding of weld joint -003 located on PCMK SSD34A-PP8.5. Welder is identified as 220067

ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U5-F.

FCAW Process:

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Welding of weld joint –003 located on PCMK SSD34A-PP8.5. Welder is identified as 220068
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2232-Tc-U5-F.

OBG # TRIAL ASSEMBLY YARD (5BW-5CW)

SMAW Process:

Welding of weld joint –013 located on PCMK OBW5A. Welder is identified as 037743
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the
WPS-B-P-2214-B-U2-FCM.

SMAW Process:

Welding of weld joint –013 located on PCMK OBW5A. Welder is identified as 054467
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the
WPS-B-P-2214-B-U2-FCM.

SMAW Process:

Welding of weld joint –023, 024 and 025 located on PCMK DP621-001. Welder is identified as 066268
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the
WPS-B-T-3213-B-U3-b.

SMAW Process:

Welding of weld joint –023, 024 and 025 located on PCMK DP627-001. Welder is identified as 068091
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the
WPS-B-T-3213-B-U3-b.

OBG # TRIAL ASSEMBLY YARD (5BW-PP34)

FCAW Process:

Welding of weld joint –041 located on PCMK SEG023C. Welder is identified as 058174
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2232-Tc-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
